#### **WORK INSTRUCTION**

Title: IV/OC Sealing Surface Finish Inspection

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Approved for Use by: Michael R. Brown Effective Date: July 2003

### Applicable Drawings:

X-106-500-SNP (Sheets 1-9) RH-TRU 72-B Packaging SARP Drawings

#### SARP Requirements:

Chapter 8.0. Annually

#### **Tools Required:**

- Surface finish comparator plate
- Surftest 211 (finish tester, or equivalent)

## Spare Parts Required:

None

### Materials Required:

- Denatured alcohol or equivalent
- Lint-free rags

#### Safety Requirements:

Safety will be observed in accordance with site requirements.

## Prerequisite Conditions:

Lids are removed and placed on stands.

#### **Instruction Steps:**

- Record all data from this instruction on the attached data sheets.
- This instruction is not required to be attached to the Maintenance Record, but may be used as a checklist during performance of maintenance.
- 1.0 If not already done, remove the IV/OC main O-rings.
- NOTE: If O-rings are being changed per annual requirement, discard. If not, clean thoroughly and place in plastic bag. Label the bag with the appropriate O-ring name and unit number.
- 2.0 Using alcohol and lint-free rags, thoroughly clean the grooves.

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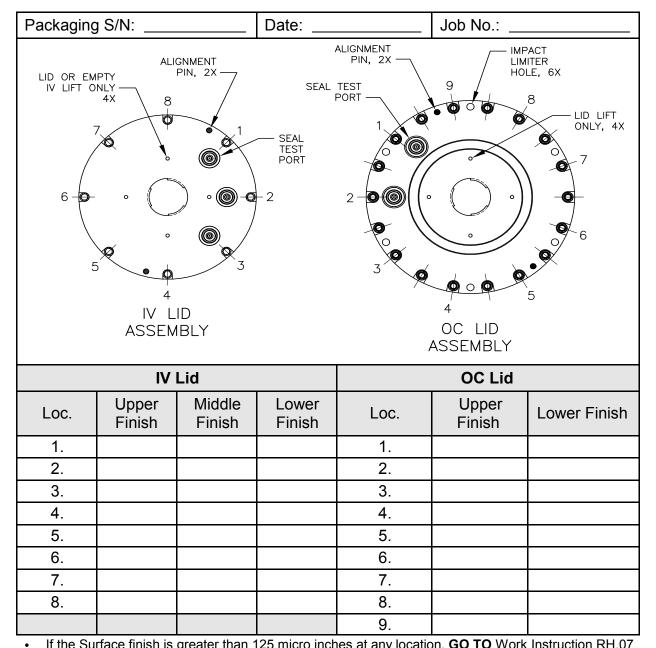
- 3.0 Using the comparator plate or Surftest 211 instrument, check surface finish of the bottom of each lid seal O-ring groove at equally spaced locations and record readings on Attachment 1, Form 1.
- NOTE: If surface finish at any location exceeds 125 micro-inches, **GO TO** Work Instruction RH.07 for repair.
- 4.0 Using the comparator plate or Surftest 211 instrument, check surface finish of the surface of the cask body O-ring sealing areas at equally spaced locations as shown on attachment and record readings on Attachment 1, Form 2.
- NOTE: If surface finish at any location exceeds 125 micro-inches, **GO TO** Work Instruction RH.07 for repair.
- 5.0 If not replacing main O-rings as part of annual maintenance, clean and reinstall main O-rings previously placed in plastic bags in accordance with Work Instruction RH.02.

## Verification Requirements:

- 1.0 Work performed is described on the Maintenance Record.
- 2.0 Work instruction is listed on the Maintenance Record.
- 3.0 Data sheets (Work Instruction RH.06, Forms 1 and 2) are attached to the Maintenance Record.

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# Attachment - 1, Form 1 - IV/OC Lid Bottom Surface Seal O-ring Groove Finish



for repair.	y location, Go To Work motitotion (1.1.0)
Comparator or Surftest 211 S/N:	Calibration Due Date:
QA:	Date:

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Attachment - 1, Form 2 - IV and OC Cask Body O-ring Sealing Surface Finish

